

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013451**Date Inspected:** 27-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Tian Lei/Chen Xi/Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay#5**

This QA inspector performed VT of cable tray components (miscellaneous) of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Components. The items designations drawing reviewed are as follows:

-(CTS1D-e, f, g, h, i, j, k), (Visual Inspection carried out on 04.26.10)

-(CTS1D1-d, h, i, j, k), (Visual Inspection carried out on 04.26.10)

**Bay#8**

During random in process inspection of the bike path component, this QA inspector observed heat straightening was performed by ZPMC personnel. After welding of X7 stiffener to stringer plates, the stringer plates distorted by 3~8mm. ZPMC QC was present during the heat straightening. According to heat straightening report, maximum distortion observed as approximately 8mm in 9200mm length. The HSR report numbers are as below.

HSR1(B)-8267- BKX8A (Stringer Plate), BK004A-PP053~062

HSR1(B)-8268- BKX8C (Stringer Plate), BK004A-PP053~062

HSR1(B)-8269- BKX9A (Stringer Plate), BK004A-PP053~062

HSR1(B)-8324- BKX9C (Stringer Plate), BK004A-PP053~062

HSR1(B)-8325- BKX10A (Stringer Plate), BK004A-PP053~062

For further information, Please find attached pictures.

# WELDING INSPECTION REPORT

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## Bay#3

SAW welding of weld joint FB3111-001-004 located on FB3111, Lift 13E. Welder is identified as 044780 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint FB3122-001-002 located on FB3122, Lift 13E. Welder is identified as 215993(1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-U3c-S-2.

FCAW welding of weld joint FB3107-001-055 located on FB3107-Lift 13E. Welder is identified as 206386 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U3-F-1.

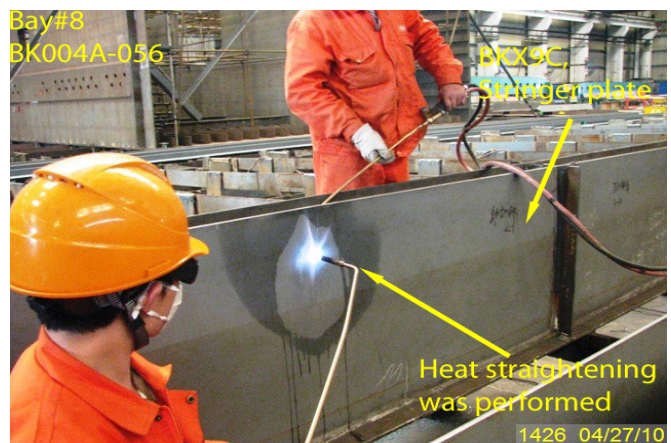
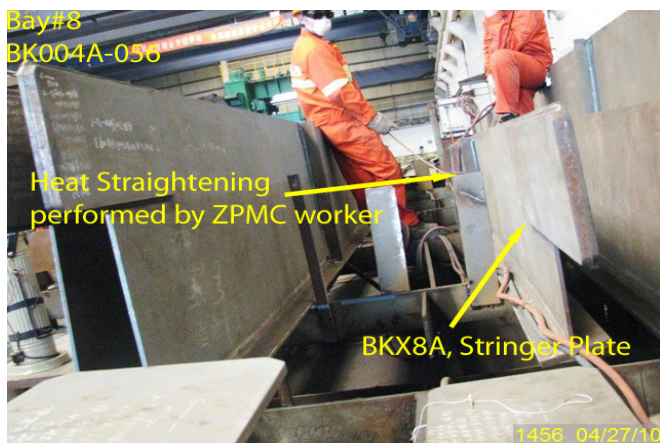
FCAW welding of weld joint FB3111-001-001 located on FB3111-Lift 13E. Welder is identified as 050977 (1G). ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U3-F-1.

## Bay#2

FCAW welding of weld joint FB3189-001-005, 006 located on FB3189-Lift 13W. Welder is identified as 045203 (1G). ZPMC QC is identified as Chen Xi. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U3-F-1.

SAW welding of weld joint FB3189-001-005, 006 located on FB3189-Lift 13W. Welder is identified as 045203 (1G). ZPMC QC is identified as Chen Xi. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-U3c-S-2.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

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## WELDING INSPECTION REPORT

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No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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